

Date: Monday, 6/25/2007 9:10:15 AM  
 User: Kim Johnston

## Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 33117		
Estimate Number	: 10710		
P.O. Number	:	Part Number	: D32111
This Issue	: 6/25/2007 S.O. No. :	Drawing Number	: D3211 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 31895	Material	:
Written By	:	Due Date	: 7/10/2007 Qty: 20 Um: Each
Checked & Approved By	: <u>John A. 25</u>		
Comment	: Est Rev:A New Issue 05-11-17 JLM		
	: Est Rev:B Now on Waterjet 06-10-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 1.4753 sf(s)/Unit Total: 29.5050 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick  
 (M2024T3S.063) Identify as D3211-1  
 Batch: 104676

ml 07 06 26

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3211  
 Dwg Rev: A1  
 Prog Rev: A1

ml 07 06 26

(10)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



ml

07 06 26



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/07/16

(X10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

SAD 07/07/19

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 33117

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

Sp 07/10/29 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sp 07/10/29 (10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/10/29 (10)

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/10/31 (10)

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BR 07-10-31 (10)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57212 07/10/01 (10)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.01

Job Completion



W 07.11.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



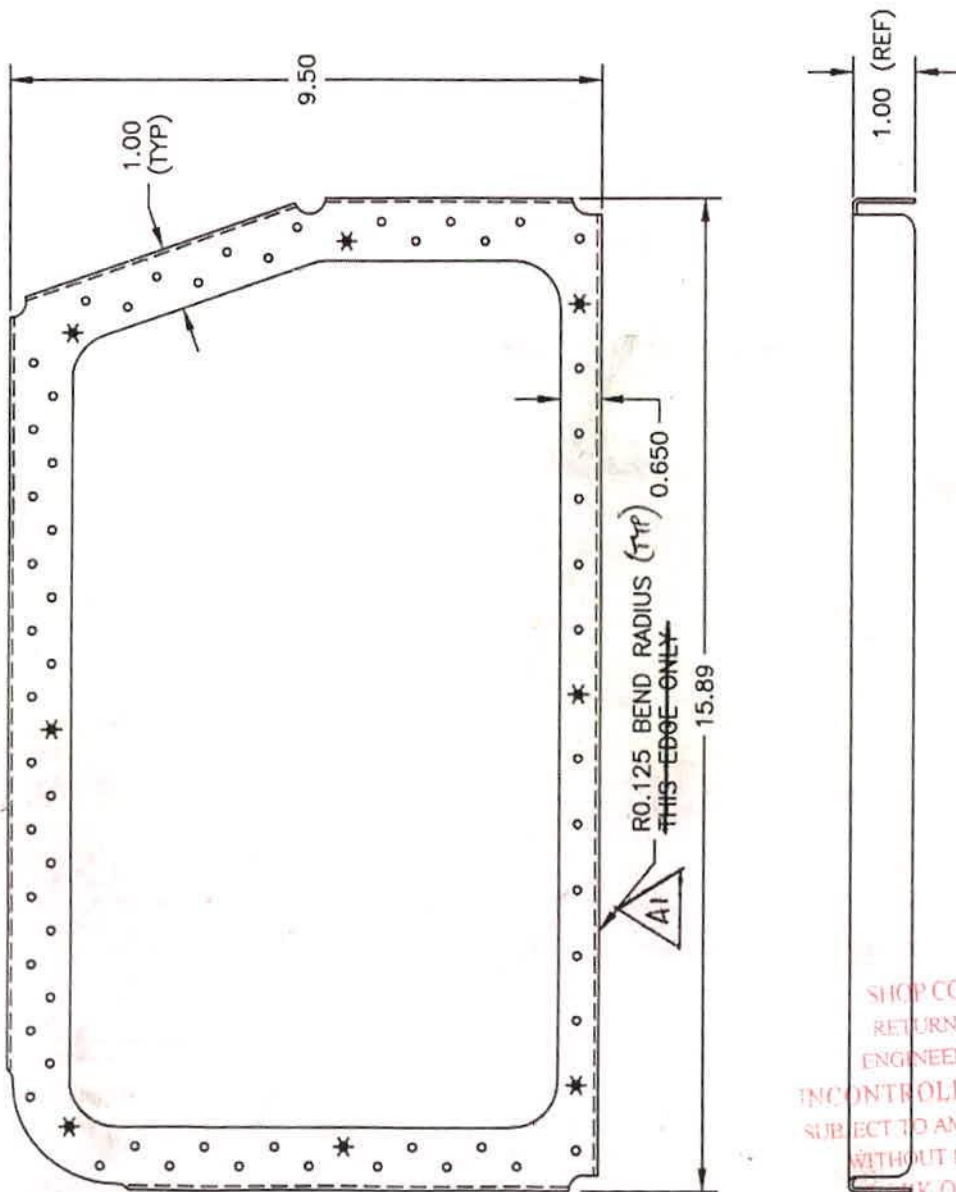




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CHECKED	AF	APPROVED	AF	DRAWING NO. D3211	REV. A SHEET 1 OF 2
DATE	03.09.03	TITLE	BRACKET	SCALE	1:3
A	03.09.03	NEW ISSUE			
AI	03.12.05	CHANGE ALL BEND RADII TO R0.125			

RELEASED  
03.09.15

D3211-1 BRACKET  
MACHINE PER DRAWING FILE "D3211-A2.DWG"  
CHECK PER TEMPLATE D3211-1T1  
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3  
USE MINIMUM BEND RADIUS OF ~~0.188~~ <sup>0.125</sup> EXCEPT WHERE INDICATED  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED







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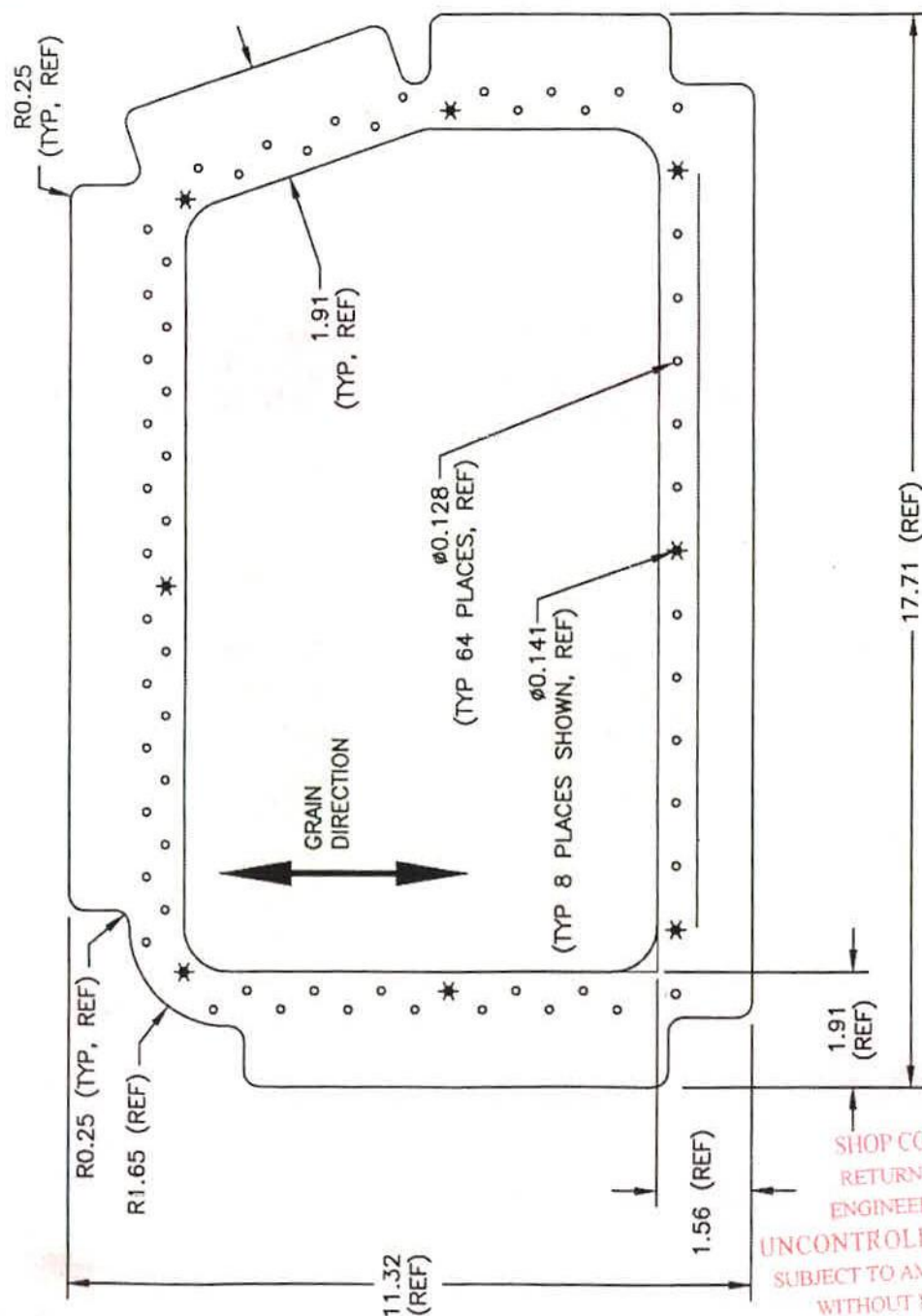
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CHECKED 	APPROVED 	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3

RELEASED  
03 09 15

D3211-1 FLAT PATTERN



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